

Date:

Tuesday, 4/18/2006 10:07:02 AM
Kim Johnston

Process Sheet

Split
SB 06/10/24

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	BRACKET ASSEMBLY
Job Number	26690			
Estimate Number	10420			
P.O. Number	N/A		Part Number	D3303043
This Issue	4/18/2006	S.O. No. : N/A	Drawing Number	D3303 REV. A
Prsht Rev.	NC		Project Number	N/A
First Issue	N/A	Type : SMALL /MED FAB	Drawing Revision	A
Previous Run	24712		Material	N/A
Written By			Due Date	5/20/2006
Checked & Approved By		KJ 06-04-18	Qty:	8
Comment	Est: A 0408.07	New Issue KJ/JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D33031	Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s) PLATE Pick: Qty Part Number Description Batch 1 D3303-1 Plate B26691	
2.0	D33033	Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 7.0000 Each(s) BRACKET Pick: Qty Part Number Description Batch 1 D3303-3 Bracket B26692	
3.0	MS20426AD33	Rivet	
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 56.0000 Each(s) RIVET Pick: Qty Part Number Description Batch 8 MS20426AD3-3 Rivet N7681	
4.0	MS20470AD44	Rivet, Universal Head	
		Comment: Qty.: 16.0000 Each(s)/Unit Total : 112.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description Batch	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 04/01/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:07:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 26690

Part Number: D3303043

Job Number:



Seq. #:	Machine Or Operation:	Description :
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16 MS20470AD4-4 Rivet

M18729

5.0 MS21075L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 28.0000 Each(s)

Nutplate

Pick:

Qty Part Number
4 MS21075L3

Description
Nut Plate

Batch *M18534*

M18729

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

- 1- Assemble as per Dwg D3303
- 2- Identify as D3303-043

EAD

06/16/26

8

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/10/26

(8)

8.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

****MASK THREADS PRIOR TO PAINT****

YL 06/10/26 X8

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 06/10/26

(7)

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

SB 06/10/26

(7)

11.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

R 06/10/27

(7)

Job Completion



U 06/10/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

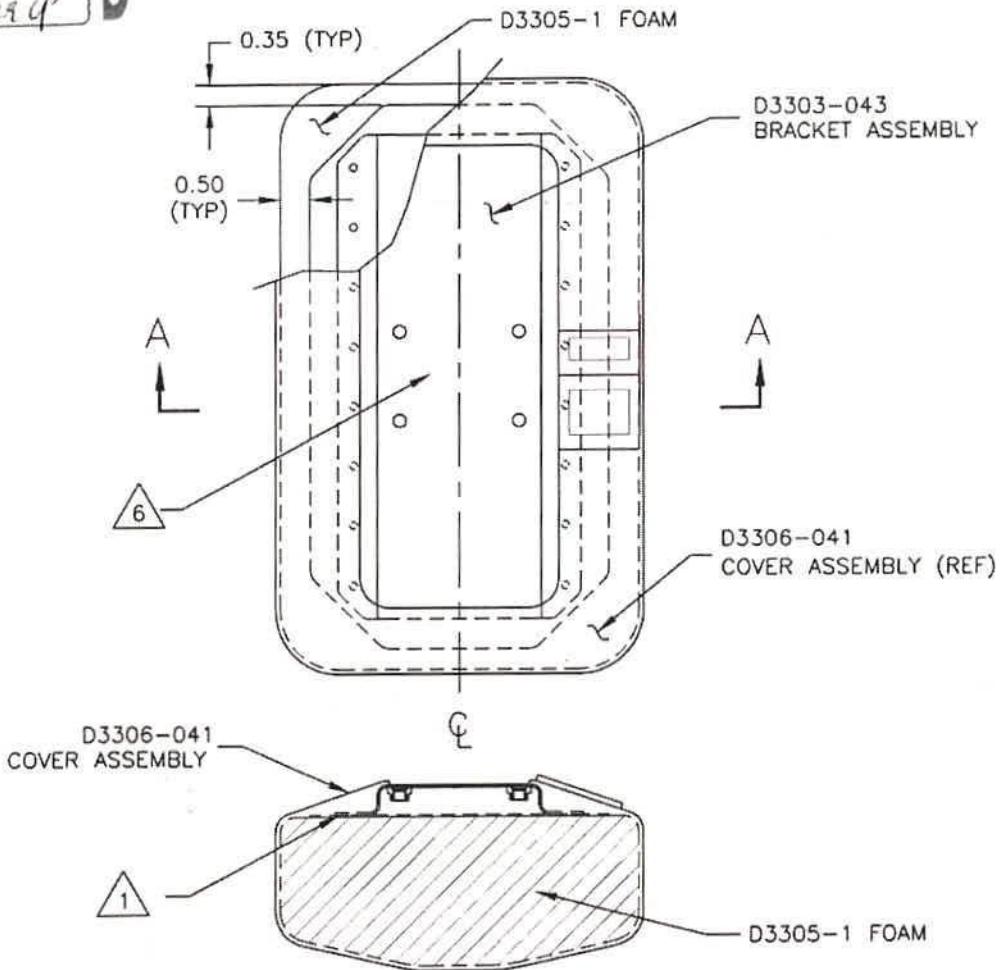
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3303	REV. A SHEET 1 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:3
A	04.08.18	NEW ISSUE	

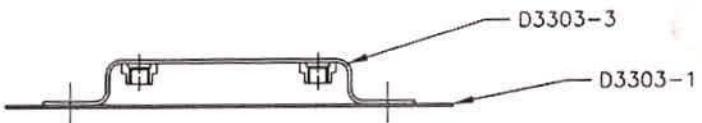
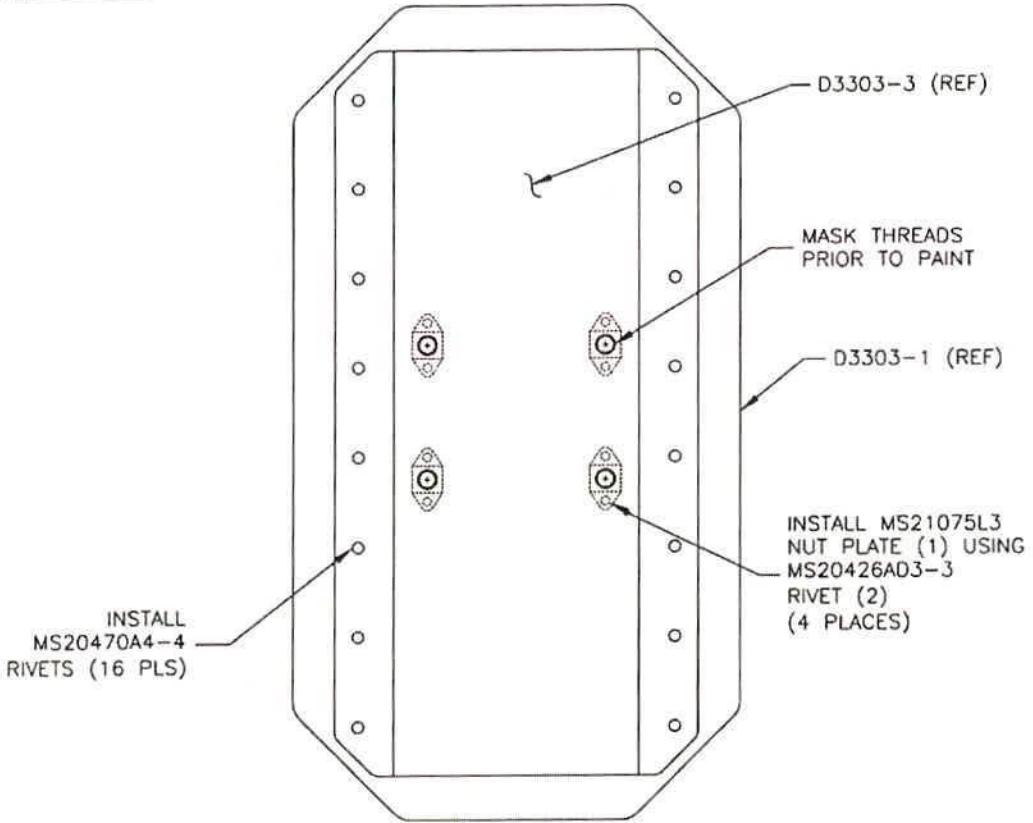
RELEASED
04.09.29 6P**SECTION A-A****D3303-041 HEAD REST****D3303-041 NOTES:**

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" to 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 AS SHOWN
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT
ELIGIBILITY SEE PDA04-11"

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *26690*

DART

DESIGN <i>RF</i>	DRAWN BY <i>HF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3303	REV. A SHEET 2 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:1

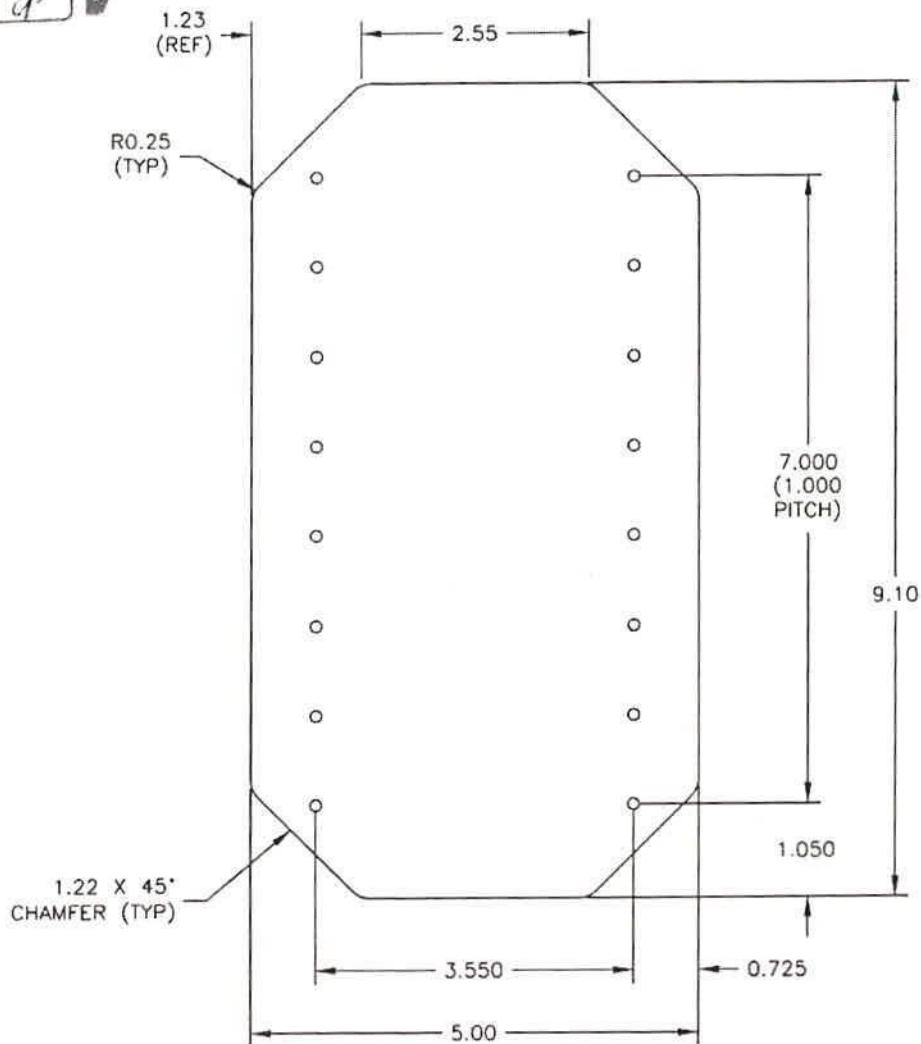
RELEASED
04.09.19 *AP***D3303-043 BRACKET ASSEMBLY****D3303-043 NOTES:**

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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NO. *26690*

DART

DESIGN <i>H</i>	DRAWN BY <i>H</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3303	REV. A SHEET 3 OF 4
DATE 04.08.18	TITLE HEAD REST	SCALE 1:2	

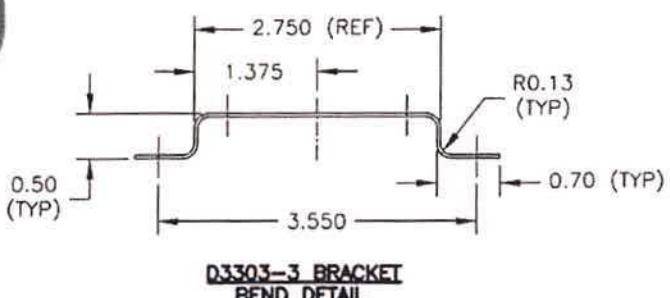
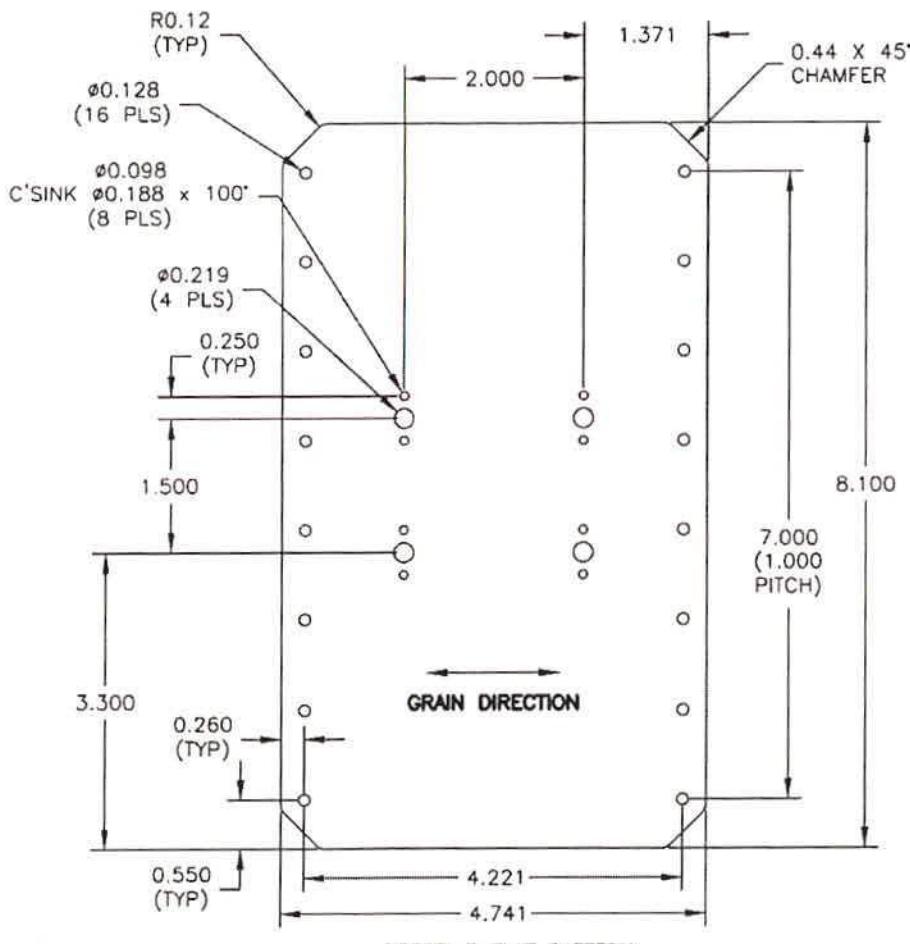
RELEASED
04.09.24 SP**D3303-1 PLATE****D3303-1 NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET (REF. DART SPEC M2024T32S-032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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NO. *Z6690*

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3303	REV. A SHEET 4 OF 4
DATE 04.08.18		TITLE HEAD REST	SCALE 1:2

**D3303-3 NOTES:**

- 1) MATERIAL: 2024-T3 (QO-A-250/4) 0.040 THICK SHEET (REF. DART SPEC M2024T32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

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WORK ORDER
NO. 26690